

Work Order ID 72915

Thursday, August 18, 2011 10:05:14 AM



Page 1

Item ID: D2724-042
Revision ID:
Item Name: 206L Step Assembly

Accept



Setup Start



Stop



Start Date: 8/18/2011 Start Qty: 2.00
Required Date: 8/18/2011 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *[Signature]* Date: *11-08-18* Tooling:
QC: Date: SPC (Y/N):

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2724	Rev C

100 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Cut D2724-2 using D2622 extrusion as per Dwg D2724
Debur and bevel ends for welding

11.10.14 2 0

110 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld end cap (One End Only) and lugs as per Dwg D2724 using Jig DT8898
followed by Jig
A/R AL ROD Batch: *114514*

Grind end cap welds flush

11.10.14 2 0

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

2 0 BE 11/10/18

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/12

72
RH

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

2x4 m-1 n/10/19
RH

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Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				2	13	11-10-20	
160 Large Fab Large Fab Large Fab	Large Fab Memo Inspect for foreign object per QSI 024 Weld Remainig end cap as per Dwg D2724 A/R AL ROD Batch: 114314 Grind end plate flush.	0.00 0.00				2	0		11.10.20
170 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							8/10/21



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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
				8 w/10/21		42 RH			
190 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
200 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo	0.00 0.00							

m117745

START TIME: 8:15
OVEN TEMPERATURE: 3200F
FINISH TIME: 8:45

2XØ m-f 11/10/21
RH
2XØ m-f 11/10/24
RH

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 8/18/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 BR 11-10-24

220

Wing Walk as per dwg QSI005 4.4 Batch 118900

0.00



HandFinish

Memo

0.00

Hand Finishing

2 BR 11-10-24

230

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 RM 11-10-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 8/18/2011 Start Qty: 2.00
Required Date: 8/18/2011 Req'd Qty: 2.00



Cust Item ID:
Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Identify as per dwg & Stock Location: _____	0.00							
	Packaging								
	Memo	0.00							
	Packaging								
250	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Memo	0.00							
	Quality Control								

PP 72912

11/10/26 SP 12

11/10/26
mf
11-10-26

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Thursday, August 18, 2011 10:05:20 AM

Page 1

Work Order ID: 72915

Parent Item: D2724-042

Parent Item Name: 206L Step Assembly



Start Date: 8/18/2011

Required Date: 8/18/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:E As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2734		Manufactured	No			110	Each	45.0000	1	2			
-------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Step End Plate

Location	Loc Qty	Loc Code
WA <u>B73196</u>	45	
70701	45	

11.10.14

D3458-1		Manufactured	No			110	Each	1.0000	2	4			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Step Mounting Plate

Location	Loc Qty	Loc Code
WA018 <u>B71593</u>	1	
63075	1	

11.10.14

D3458-3		Manufactured	No			110	Each	8.0000	2	4			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Step Mounting Plate

Location	Loc Qty	Loc Code
WA018 <u>B73327</u>	8	
63076	8	

11.10.14

D2734		Manufactured	No			160	Each	45.0000	1	2			
-------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Step End Plate

Location	Loc Qty	Loc Code
WA <u>B73196</u>	45	
70701	45	

11.10.20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Thursday, August 18, 2011 10:05:20 AM

Page 2

Work Order ID: 72915



Parent Item: D2724-042



Parent Item Name: 206L Step Assembly

Start Date: 8/18/2011

Required Date: 8/18/2011

Start Qty: 2.00

Required Qty: 2.00

D2622-120C

Manufactured No

100

Each

82.7000

1

2



Step Extrusion

8.11.10.14

Location

Loc Qty

Loc Code

HALL

372131

73

64409

6

68293

67

WA

9.7

46910

2

66970

7.7

2

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Shop Packet Print

Page 2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

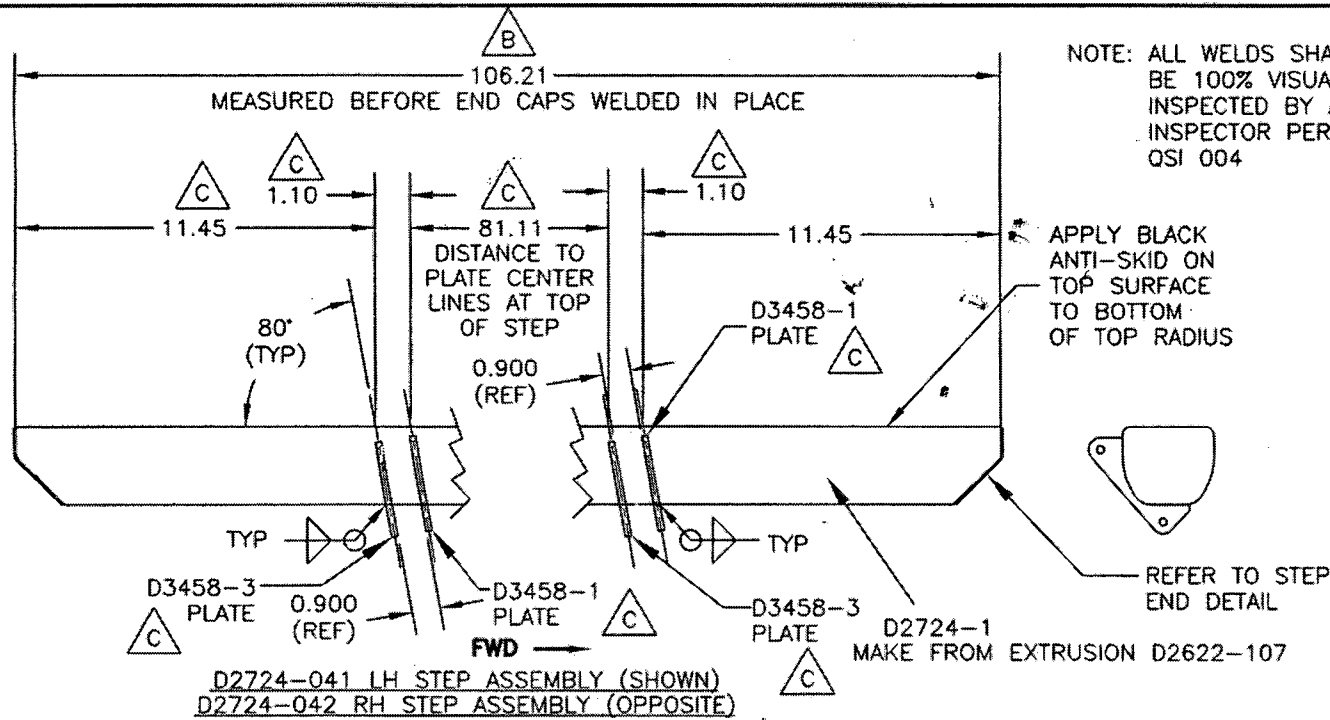
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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DART

RELEASED
05.11.14

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



D2721-041/-042 STEP ASSEMBLY PARTS LIST

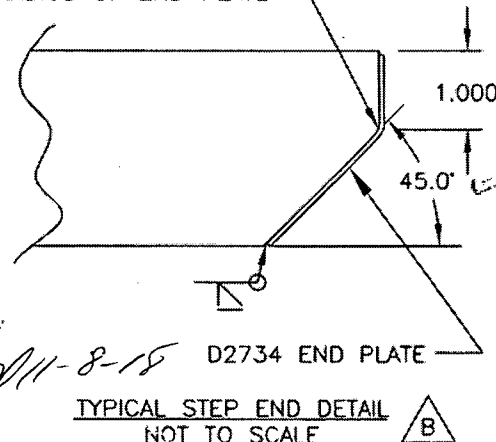
QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72915

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

DESIGN	DRAWN BY	DATE	CHECKED	APPROVED	TITLE	REV. C
KE	PH	05.09.19			D2724	
B		98.10.19			206L/407 STEP ASSEMBLY	
C		05.09.19			RE-DESIGN, ADD D3458-1/-3	
					NEW ISSUE	
					UPDATED WELD DETAIL REVISED TOLERANCES	
					SCALE	
					SHEET 1 OF 1	

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